

Work Order ID 77617

December-13-11 4:26:50 PM

77617

Page 1

Item ID: D3535-25 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Wearshoe
 Start Date: 13/12/2011 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 05/01/2012 Req'd Qty: 12.00 ***12*** Customer:
 Reference:

Approvals: Process Plan: M.C.J Date: 11/12/13 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3535	Rev B

100 FLOW WATER JET 0.00
100
 Waterjet Memo 0.00
 FLOW CNC Waterjet 1-Cut as per Dwg D3535 Dwg Rev: B Prog Rev: B 2-
344-010 Deburr if necessary

B11-12-22

(13)

110 QC2- Inspect parts off machine FAI/FAIB 0.00
110
 QC Memo 0.00
 Quality Control

B11-12-22

120 QC8- Inspect parts - second check 0.00
120
 QC Memo 0.00
 Quality Control

8/12/23

(13)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 77617

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Page 2

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Brake NC	NC BRAKE Memo 1-Form on CNC Brake as per Dwg D3535 using Jigs DT8261 and DT83262- Form joggle on Punch as per Dwg D3535 using Jig DT8158 Identify as D3535-25	0.00 0.00				(n)	(n)		PTO
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							8/12/10/09
150 *150* Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 Memo START TIME: 3:00 FINISH TIME: 3:30	0.00 0.00							12xpm 12/01/11

W118484

32001

3:30

W/O: 77617		77617 WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3535-25 PAR #: _____ Fault Category: Small FAB NCR: Yes No DQA 12/1/17 Date: 12/1/17
12-1114 Resolution: SCRAP Disposition: SCRAP QA: N/C Closed 12/1/17 Date: 12/1/17

NCR: <u>12-1114</u>		WORK ORDER NON-CONFORMANCE (NCR) <u>15.14</u>						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/01/09	130	found 1 piece missing half of the top when cut on w/ set R.C Process	S 12/01/09 057042	Drop & destroy No replace	SB 12/01/09	S 12/01/09	S 12/01/09 057042	S 12/01/09

NOTE: Date & initial all entries

December-13-11 4:26:50 PM

77617

Page 3

Accept

N900040100

Setup Start ***NS1***

Stop *NS2*

Start Date: 13/12/2011 **Start Qty:** 12.00

12

Cust Item ID:**Required Date:** 05/01/2012 **Req'd Qty:** 12.00

12

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160 QC3- Inspect Part Finish

0.00

160

QC

Memo

0.00

Quality Control

170	Identify as per dwg & Stock Location:	FD-2	0.00
-----	---------------------------------------	------	------

170

Packaging

0.00

Packaging

180	QC21- Final Inspection - Work Order Release	0.00
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180

QC

Memo

0.00

Quality Control

ME
12-01-12

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NOTE: Date & initial all entries

Picklist Print

December-13-11 4:26:54 PM

Page 1

Work Order ID: 77617

77617

Parent Item: D3535-25

D3535-25

Parent Item Name: Wearshoe

Start Date: 13/12/2011

Required Date: 05/01/2012

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 07-02-15 JLM
IPP Rev:B As per Rev B 07-08-31 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA		Purchased	No			100	sf	257.5165	0.51	6.442105			

M304S20GA

304/316 .040 Sheet

B142-22

Location

Loc Qty

Loc Code

MAT020

257.5165

116623

0.2

117933

27.3442

118400

25.6723

118964

36.5

119346

167.8

119346

(13)

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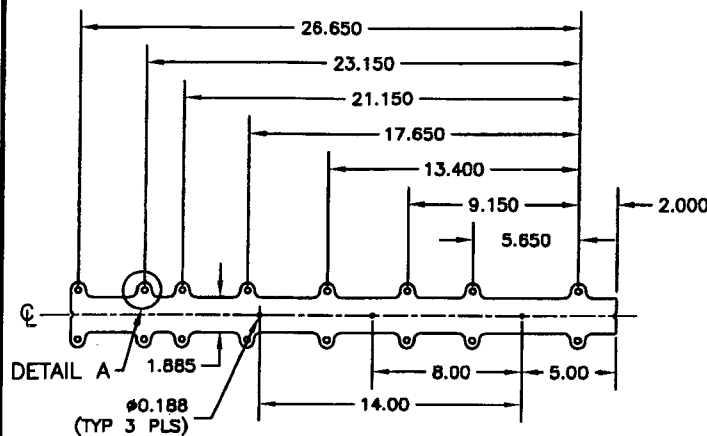
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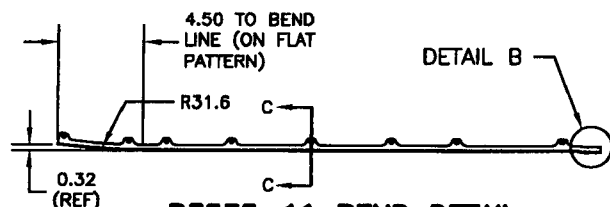
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07.04.24

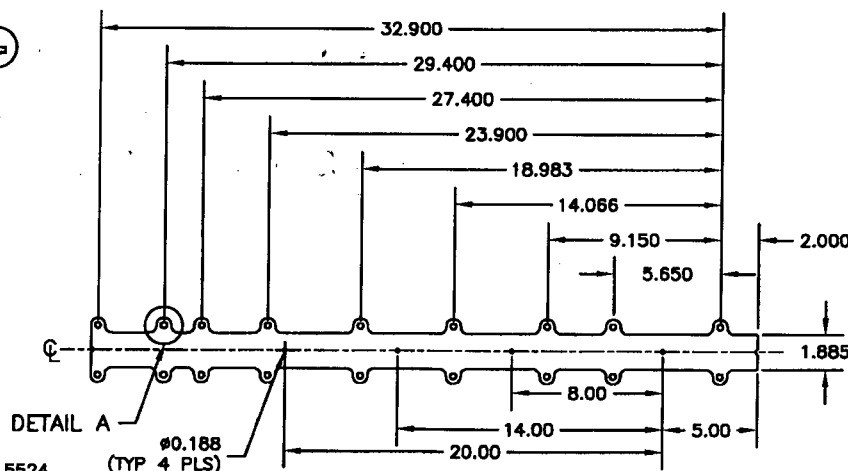
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED
SUBJECT TO APPROVAL
WITHOUT EFFECT
WORK ORDER
NO. 77617 M.L.J
11/12/13



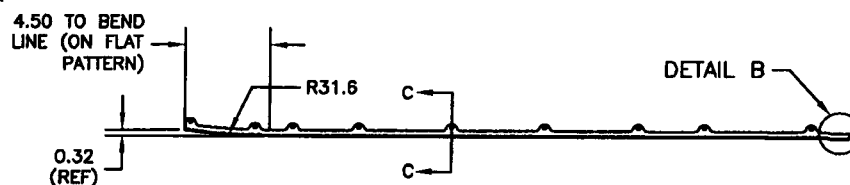
D3535-11F FLAT PATTERN



D3535-11 BEND DETAIL



D3535-13F FLAT PATTERN



D3535-13 BEND DETAIL

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

DESIGN	DRAWN BY	TITLE	REV. B
CB	PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	SHEET 1 OF 7
PH	PH	D3535	
DATE	DATE	SCALE	
07.04.17	06.10.25	1:10	
	07.04.17		
A		WEARSHOE	
B		NEW ISSUE	
		MOVE TAB OUTBOARD, ADD AMS SPEC	

W/O:		WORK ORDER CHANGES					
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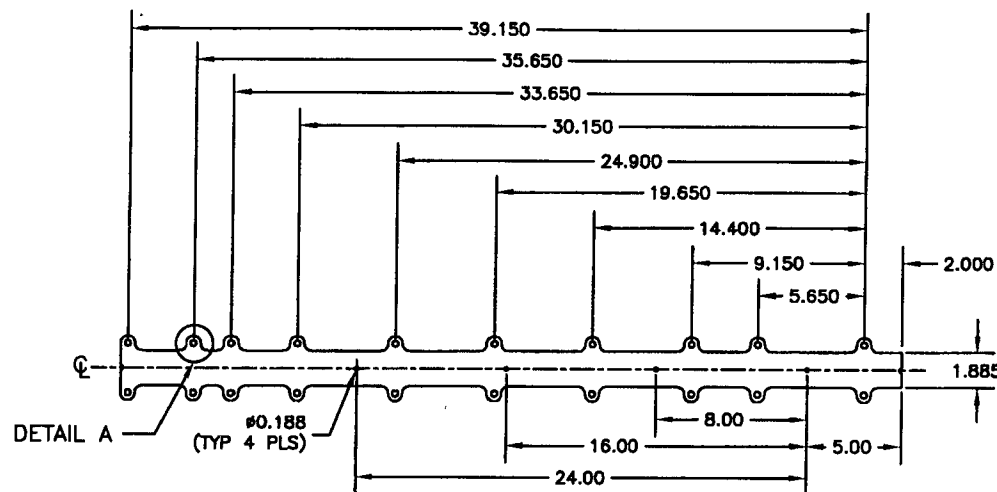
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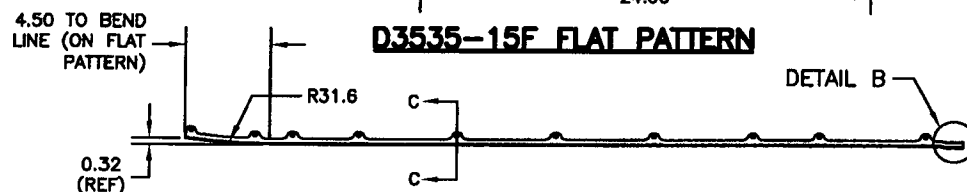
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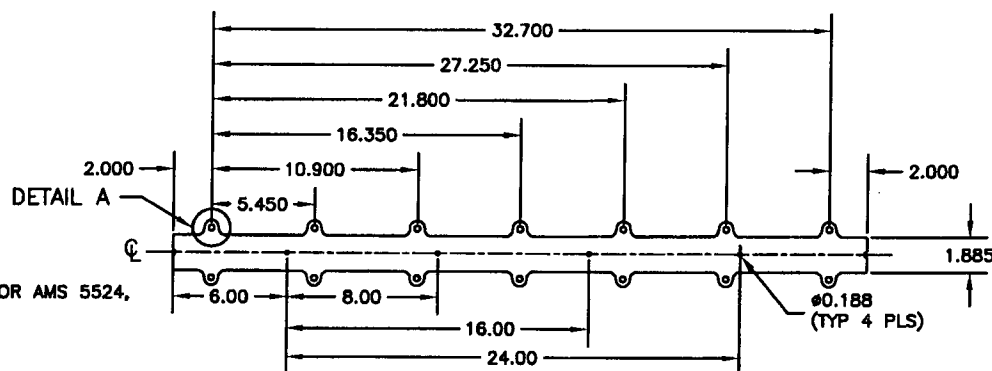
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CHECKED		APPROVED		PORT HADLOCK, WA
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				REV. B
				SHEET 2 OF 7
				SCALE
				1:10



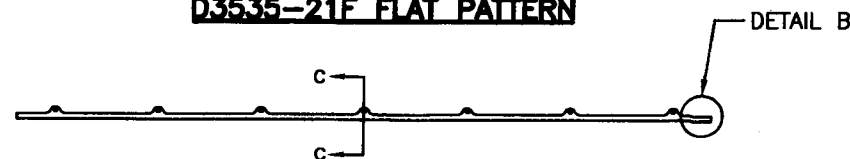
D3535-15F FLAT PATTERN



D3535-15 BEND DETAIL



D3535-21F FLAT PATTERN



D3535-21 BEND DETAIL

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
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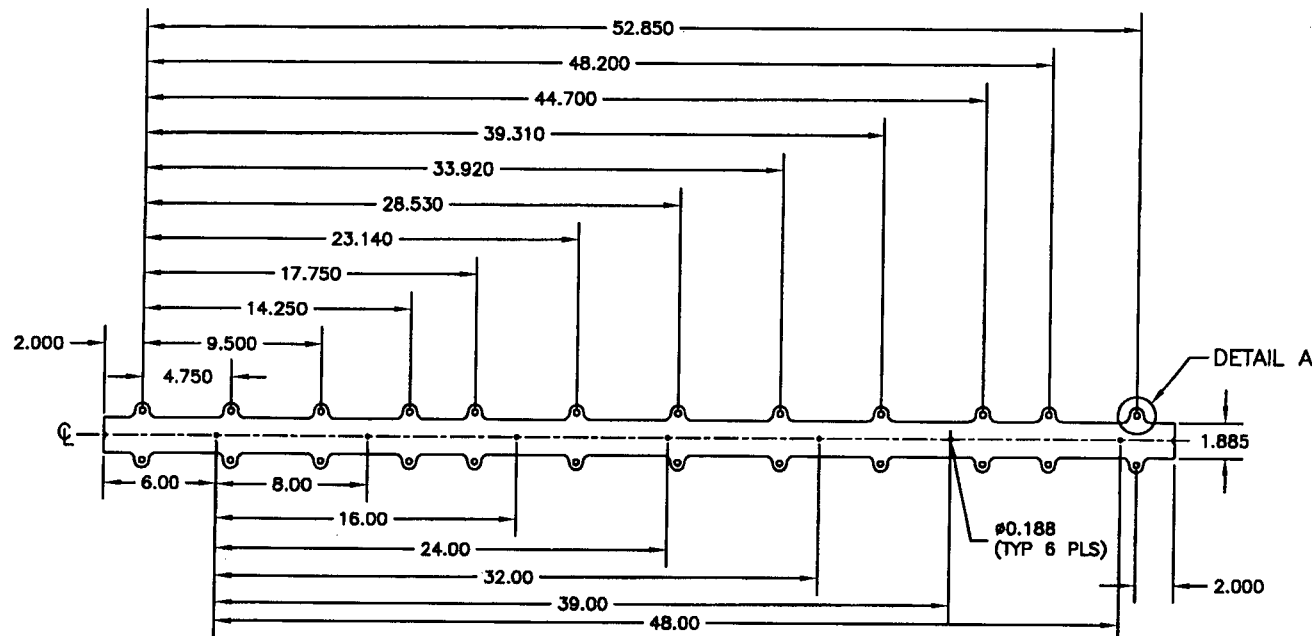
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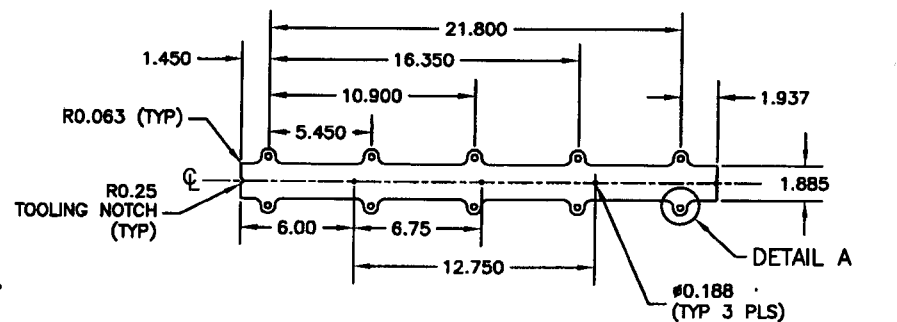
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DATE	07.04.17	TITLE	D3535	WEARSHOE
				SCALE
				1:10
				REV. B
				SHEET 3 OF 7

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07.04.24



D3535-23F FLAT PATTERN

D3535-23 BEND DETAIL



D3535-25F FLAT PATTERN

D3535-25 BEND DETAIL

NOTES

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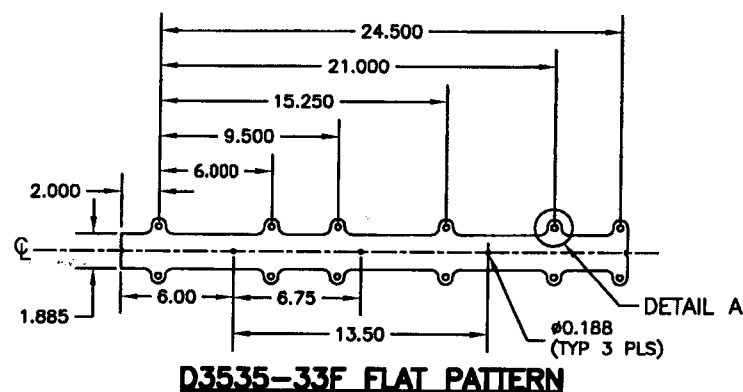
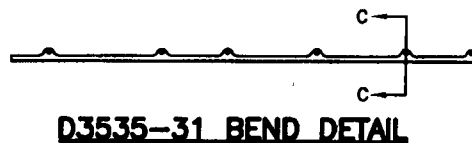
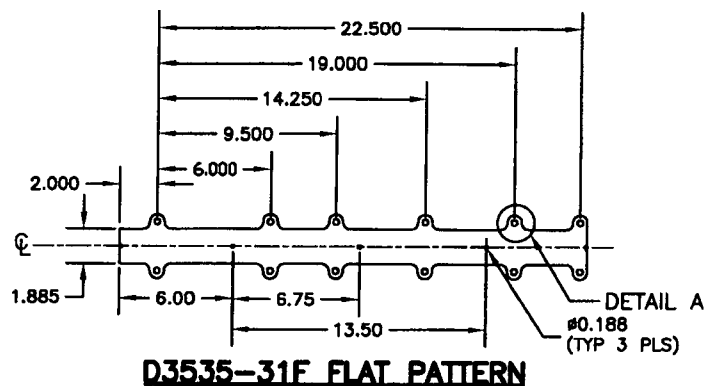
NOTE: Date & initial all entries

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3535	REV. B
DATE 07.04.17	TITLE WEARSHOE	SHEET 4 OF 7	SCALE 1:10

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07.04.24



NOTES

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(REF DART SPEC M304S20GA)
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

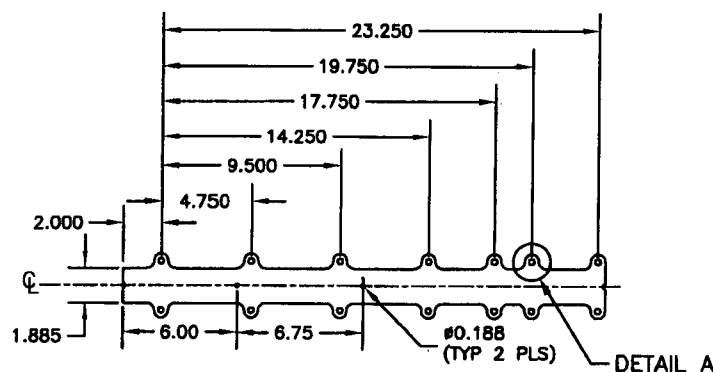
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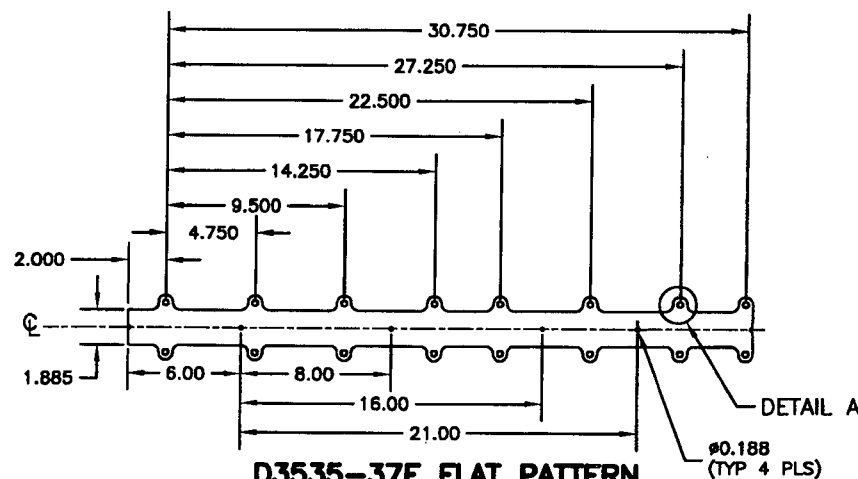
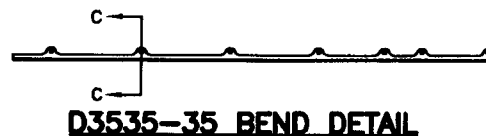
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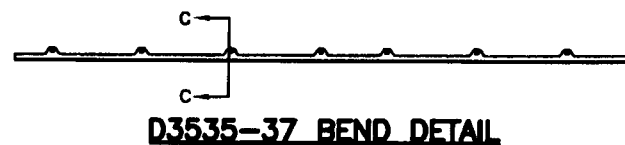
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DATE	07.04.17	TITLE	D3535	WEARSHOE
		SCALE	1:10	
		SHEET 5 OF 7		
		REV. B		



D3535-35F FLAT PATTERN



D3535-37F FLAT PATTERN



NOTES

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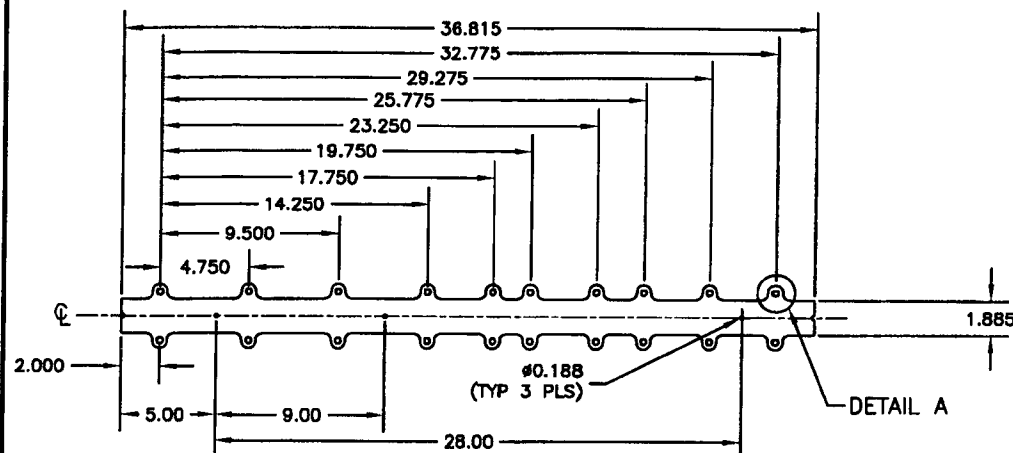
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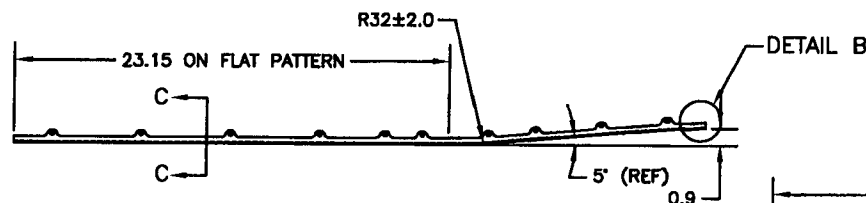
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07.04.17

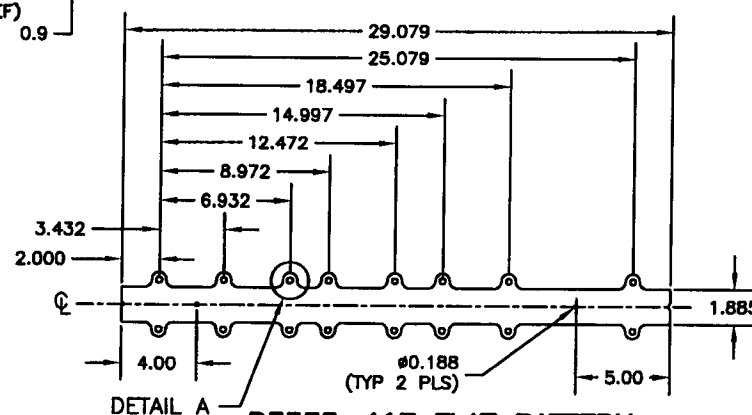
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DATE	TITLE	SCALE	
07.04.17	WEARSHOE	1:10	



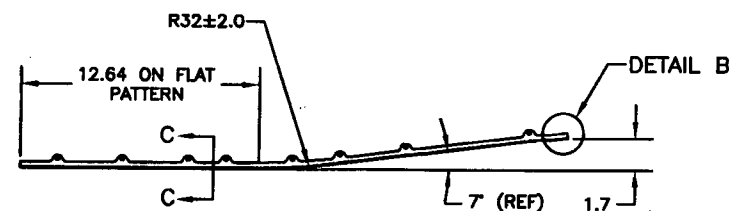
D3535-39F FLAT PATTERN



D3535-39 BEND DETAIL



D3535-41F FLAT PATTERN



D3535-41 BEND DETAIL

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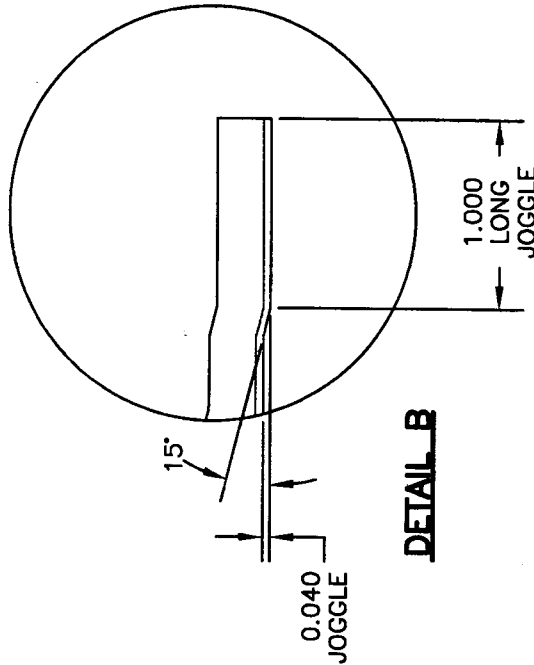
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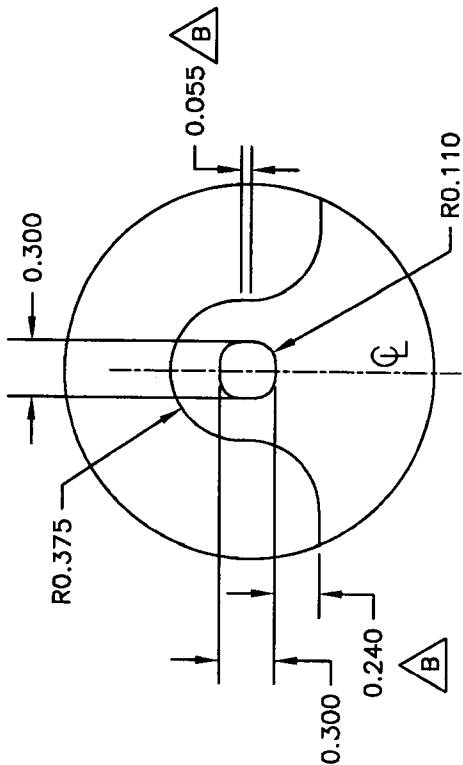
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DATE 07.04.17	TITLE WEARSHOE		SCALE 1:1

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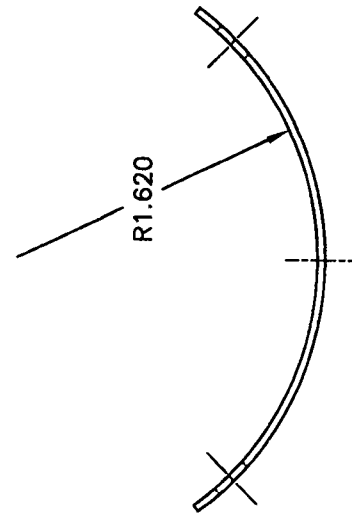
07.04.24



DETAIL B



DETAIL A



SECTION C-C

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries